wherein the gasket layer sections are moved further along the direction of feed by a feed distance by means of a feeding device between two operating cycles,

wherein the outer contour lines of the two adjacent gasket layers are cut with the same cutting edge of the tool for cutting outer contour lines and wherein the feed distance is selected to be essentially the same as the extension of the outer contour of a finished gasket layer or a group of finished gasket layers along the direction of feed, ~~and~~

~~wherein at least one of the machining stations is designed as a free-cutting station arranged in front of the station for cutting outer contour lines in the direction of feed, said free-cutting station having at least one free-cutting tool for cutting at least one free-cutting area out of the starting material in said free-cutting station, said free-cutting tool having a corner-free shape to its cutting edge and the cutting edge of the tool for cutting outer contour lines of the station for cutting outer contour lines dipping into said free-cutting area during the cutting procedure~~

wherein the outer contour of said first gasket layer is provided with a corner,

wherein said second gasket layer is produced by means of a follow-on combination tool, the feed distance with said tool being greater than the extension of the outer contour of said second gasket layer along the direction of feed,

and wherein said first gasket layer and said second gasket layer are disposed one on the other to form said multi-layer gasket such that said second gasket layer projects beyond said corner on said first gasket layer.

10.(Canceled)

11.(currently amended) Process as defined in claim [[9]] 24, wherein the free-cutting area is cut by the free-cutting tool of the free-cutting station such that the edge of the free-cutting area extends transversely to the outer contour lines cut by the tool for cutting outer contour lines.

12.(Original) Process as defined in claim 11, wherein in that the free-cutting area is cut by the free-cutting tool of the free-cutting station such that the edge of the free-cutting area extends essentially at right angles to the outer contour lines cut by the tool for cutting outer contour lines.

13.(Original) Process as defined in claim 9, wherein the adjacent gasket layers are separated completely from one another in the station for cutting outer contour lines designed as a separating station.

14.(Original) Process as defined in claim 13, wherein the station for cutting outer contour lines is the last machining station of the follow-on combination tool in the direction of feed.

15.(Original) Process as defined in claim 9, wherein the outer contour lines are cut in the station for cutting outer contour lines by means of a cutting edge formed by surfaces of the tool for cutting outer contour liens forming with one another an angle of approximately 90°.

16.(Original) Process as defined in claim 9, wherein the feed distance is selected to be essentially the same as the extension of the outer contour of a group of finished gasket layers and that adjacent gasket layers of the group are separated completely from one another in a separating station.

17.(Original) Process as defined in claim 16, wherein the group of gasket layers comprises at least two gasket layers, the facing outer contour lines of said layers being cut with the same cutting edge of a tool for cutting outer contour lines.

18.(Original) Process as defined in claim 16, wherein the group of gasket layers comprises at least two gasket layers, the outer contour lines of said layers being designed to be essentially point symmetric to one another.

19. (Currently amended) Gasket, comprising at least a first gasket layer and a second gasket layer disposed one on the other to form a multi-layer gasket,

wherein an outer contour of the first gasket layer comprises a free-cutting line cut ~~by a free-cutting tool~~ and an outer contour line ~~cut by a tool for cutting outer contour lines~~, said free-cutting and outer contour lines together forming a corner, and

wherein said second gasket layer projects beyond the corner on the first gasket layer when said first gasket layer and said second gasket layer are disposed one on the other in said multi-layer gasket.

20. (Canceled)

21. (Canceled)

22. (Currently amended) Gasket, comprising at least a first gasket layer and a second gasket layer disposed one on the other to form a multi-layer gasket,

wherein an outer contour of the first gasket layer comprises a free-cutting line cut by a free-cutting tool and an outer contour line cut by a tool for cutting outer contour lines, said free-cutting and outer contour lines together forming a corner, and

wherein said second gasket layer comprises ~~an~~ a first outer contour line section following a course of the outer contour line of the first gasket layer or a course of the free-cutting line of the first gasket layer when said first gasket layer and said second gasket layer are disposed one on the other in said multi-layer gasket, and[[,]] a second outer contour line section smoothly adjoining said first outer contour line section of the ~~first~~ second gasket layer in the area of the corner of the first gasket layer when said first gasket layer and said second gasket layer are disposed one on the other in said multi-layer gasket.

23.(previously presented) Gasket as defined in claim 22, wherein the additional gasket layer is produced by means of a follow-on combination tool, the feed distance with said tool being greater than the extension of the outer contour of the finished gasket layer along the direction of feed.

24.(new) Process as defined in claim 9, wherein at least one of the machining stations is designed as a free-cutting station arranged in front of the station for cutting outer contour lines in the direction of feed, at least one free-cutting area being cut out of the starting material in said free-cutting station, the cutting edge of the tool for cutting outer contour lines of the station for cutting outer contour lines dipping into said free-cutting area during the cutting procedure.

25. (new) Process for the production of a multi-layer gasket comprising at least a first gasket layer and a second gasket layer,

wherein said first gasket layer is produced from one respective gasket layer section of a starting material comprising several continuous gasket layer sections, wherein the gasket layer sections are machined during operating cycles in a follow-on combination tool having several machining stations following one another along a direction of feed, wherein at least one of the machining stations is designed as a station for cutting outer contour lines, facing outer contour lines of two adjacent gasket layers being cut in said station by means of a tool for cutting outer contour lines, and

wherein the gasket layer sections are moved further along the direction of feed by a feed distance by means of a feeding device between two operating cycles,

wherein the outer contour lines of the two adjacent gasket layers are cut with the same cutting edge of the tool for cutting outer contour lines and wherein the feed distance is selected to be essentially the same as the extension of the outer contour of a finished gasket layer or a group of finished gasket layers along the direction of feed,

wherein the outer contour of said first gasket layer is provided with a corner,

wherein said second gasket layer is produced by means of a follow-on combination tool, the feed distance with said tool being greater than the extension of the outer contour of said second gasket layer along the direction of feed,

and wherein said first gasket layer and said gasket layer are disposed one on the other to form said multi-layer gasket such that a first outer contour line section of said second gasket layer follows a course of an outer contour line said first gasket layer and a second outer contour line section of said second gasket layer smoothly adjoins said first outer contour line section of said second gasket gasket layer in the area of said corner of said first gasket layer.